Page 1

Wednesday, Aug	ust 31, 2011 1:44:43 PM			3					- Tuge 1
Revision ID:	D3557-1 Bracket		Accept			 \$	Setup Star Stop	1	
	9/1/2011 Start Qty: 24.00	1 100115 (1011 0101 1001		Cust Item ID: Customer:				}	
Approvals:	Process Plan:QC:		Tooling: SPC (Y/N):			F	Run Star Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID T		Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3557	Rev A								•
Waterjet FLOW CNC Waterje		er Dwg D3557				BIL	9-8	32	
110 QC Quality Control	QC2- Inspect parts off i	nachine FAI/FAIB	0.00			(311	- લ-૧)
120 QC Quality Control	QC8- Inspect parts - sec Memo	cond check	0.00	ils	(·	433)			

W/O:	T		W	ORK ORDER CHANGI	ES			1	
DATE	STEP	PRO	OCEDURE CHA		Ву	Date 0	Qty	Approval Chief Eng /	Approval QC Inspector
								Prod Mgr	GO INSPECTO
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Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA:		Date: _	
	Re	esolution:	Disposition	on:	_ QA: N/C Clo	sed:		_ Date:	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
	0===	Description of NC		Corrective Action Section		Verificat	ion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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Work Order ID 73384

Wednesday, August 31, 2011 1:44:43 PM



Page 2

Item ID:

D3557-1

Accept



Setup Start



Revision ID:

Item Name: **Start Date:**

Bracket

9/1/2011

Start Qty: 24.00 Req'd Qty: 24.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Date:

Run

Start

Stop

Stop



Required Date: 9/12/2011

QC:____

Date:

SPC (Y/N):

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Sequence ID/ **Work Center ID**

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Memo

Bend as per Dwg D3557

Set Up/ **Run Hours**

0.00

0.00

SD 11/09/13

30.00

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

Memo

0.00

W/O:			W	ORK ORDER CHAI	VGES			-		
DATE	STEP	PRO	OCEDURE CHA			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCI	R: Yes I	No DQ	A:	_ Date: _	
	Re	esolution:	Dispositio	n:	QA:	N/C CIC	sed:		Date: _	and the second second second
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DATE	OTED	Description of NC	,		Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	on	Sign & Date		tion C	Chief Eng	QC Inspector
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Work Order ID 73384 Wednesday, August 31, 2011 1:44:43 PM Item ID: D3557-1 Accept Setup Start **Revision ID:** Stop Item Name: Bracket **Start Date:** 9/1/2011 Start Qty: 24.00 **Cust Item ID:** Required Date: 9/12/2011 Req'd Qty: 24.00 **Customer:** Reference: Start Run Date: ____ **Approvals:** Process Plan: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject **Work Center 1D** Description Qty Qty **Run Hours** Code Number 160 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 Powdercoat 0.00 Powder Coating START TIME: □OVEN TEMPERATURE:

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Insp.

Stamp

Page 3

180

Identify as per dwg & Stock Location ()

0.00

Packaging

Memo

0.00

Packaging

Dart Aei	ospace	: Llu							-
W/O:			WO	RK ORDER CHANG	ES	.,			
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	
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NCR:		V	WORK ORDE	ER NON-CONFORMA	ANCE (NCF	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng	ion B Sign & Date	Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 73384

Wednesday, August 31, 2011 1:44:43 PM



Page 4

Item ID:

D3557-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 9/12/2011

Bracket

9/1/2011

Start Qty: 24.00

Req'd Qty: 24.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run



Stop

Sequence ID/

Work Center ID

QC21- Final Inspection - Work Order Release

Set Up/ Run Hours

0.00

Tool ID

Tool # Plan Code

Reject Accept Qty Qty

Reject Number

Insp. Stamp

190

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		Description of NC		Corrective Action Section I	B	Verification	Annuoval	Approval QC Inspector				
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NOTE: D	ate & initial a	11										

Picklist Print

Wednesday, August 31, 2011 1:44:39 PM

Work Order ID: 73384

Parent Item:

D3557-1

Parent Item Name:

Bracket



Start Date: 9/1/2011

Required Date: 9/12/2011

Page 1

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP Rev:A

New Issue 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No		100	sf	131.1700	0.0343	0.866526	1-5		
									14. II.	-G-2		

6061-T6 .125 Sheet

Location	Loc Qty	Loc Code	
MAT021	131.17		
113608	77.17		
118217	54		118217

W/O:			WO	RK ORDER CHA	NGES				
DATE	STEP	PRO	CEDURE CHAN	IGE		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Categ	ory:	NCF	R: Yes N	lo DQA:	Date: _	
		esolution:	•						
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DATE	STEP	Description of NC		Corrective Action	Section B	Ciam 9	Verification		Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Descript Chief Eng	ion	Sign & Date	Section C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	13384
Description: Bracket	Part Number:	D3557-1
Inspection Dwg: D3557 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.172	+0.005/-0.001	.174	6		U BOD	
Ø0.323	+0.006/-0.001	366.	يح		V	
2.75	+/-0.030	2.754	>		ν	
1.790	+/-0.010	1.794	>		V	
0.345	+/-0.010	,346	2		V	
1.445	+/-0.010	1,445	7		V	
0.375	+/-0.010	376	٢		V	
2.250	+/-0.010	5.752	3		V	
					`	
		•				

Measured by:	B	Audited by:		Protot	ype Approval:	N/A
Date:	11-9-8	Date:	11/09/09		Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.03.21	New Issue	KJ/JLM 🛠	E

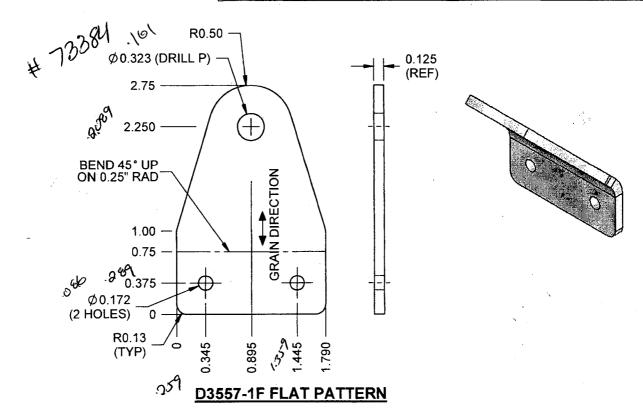
Dart Aerospace I	Lta
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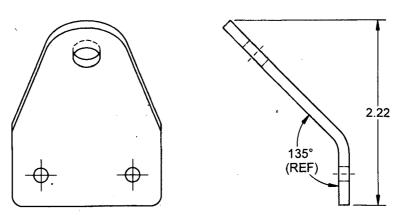
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Part No	<u> </u>	PAR #:	Fault Cated	lorv:	NCR: Yes	No DQ	A:	Date:	
Resolution:		Disposition:		QA: N/C Closed:			Date:		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	₹)			
DATE	STEP	Description of NC	Corrective Action Section			Verifi	Verification	Approval	Approval
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DESIGN DRAWN BY			DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
	CHECK	(ED	APPROXED	DRAWING NO.	REV. A		
	0	PH	4	D3557	, SHEET 1 OF 1		
	06.09.15		ŤITLE	SCALE			
			BRACKET	1:1			
	REV		DATE		DESCRIPTION		
i	Α		06.09.15	NEW ISSUE			





D3557-1 BRACKET

NOTES: 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11

- (REF DART SPEC M6061T6S.125) 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- POWDER COAT WHITE (4.5.3.1) PER DART QSI 005 4.3
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

- 6) IDENTIFY WITH P/N D3557-1 USING FINE POINT PERMANENT MARKER



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W/O:			WO	RK ORDER CHANGI	ES			-	
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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